

Date: Wednesday, 5/31/2006 7:35:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 STEP END PLATE
Job Number	: 27281		
Estimate Number	: 11021		
P.O. Number	: N/A	Part Number	: D2734
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D2734 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/25/2006
Checked & Approved By	: <u>06-05-31 W</u>	Qty:	200 Um: Each
Comment	: Est:D 01.06.08 Removed Debur EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.063" thick
 (M5052H32S.063) Batch: mm296

mm 06 06 07

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks: 3.035" +0.000/-0.010 X 2.90 +0.030/-0.010
 Grain along 3.035"

3.0	HAAS1 Water Jet	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2734
 Flat pattern is the same as D2875

Prog. Rev. B

Dwg Rev. B

mm 06 06 07 (200)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mm 06 06 07

(200)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mm 06 06 07 (200)
Count (199)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Form per drawing D2734

SP 06/06/19

199

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-21

199

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA

06-06-21

199

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/06/22

199

Job Completion



u 06-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

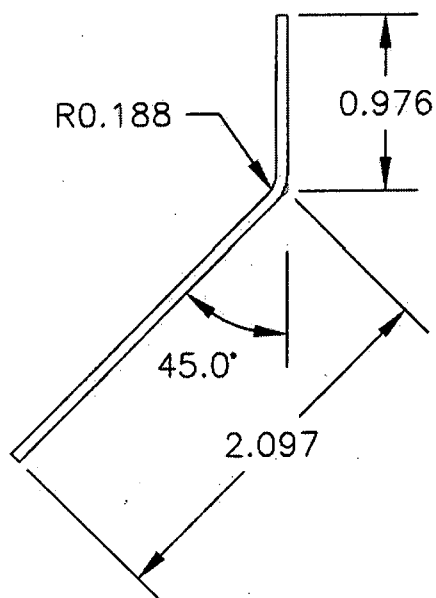
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

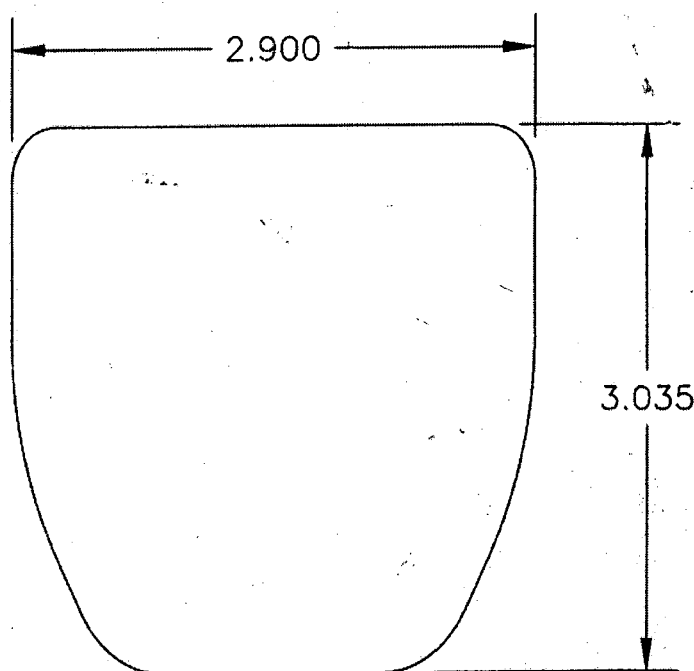


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>RH</i>	APPROVED <i>SA</i>	DRAWING NO. D2734	REV. B SHEET 1 OF 1
DATE 98.10.05		TITLE END PLATE	SCALE 1:1
A	97.12.10	NEW ISSUE	
B	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137	

RELEASED
99/10/05 KE



BEND DETAIL



FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27281

MATERIAL: 5052-H32 (QQ-A-250/8) OR
6061-T6 (QQ-A-250/11) 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED